



Dart Aerospace Ltd.
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647.7710

Job Sheet 208873



Part No: 647.7710

Job Qty: 16 pcs

Part Name: Strut Tube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/2/20

Job Tracking No:

Due Date: 6/5/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A2 IPP REV:A 12.11.06 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	Conventional Mill - 1	16 pcs	6/5/20	6/5/20	0.00	142.22	Conventional Mill - 1	
							Conventional Mill - 2	
120	QC 2	16 pcs	6/5/20	6/5/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	



Container No: S278966



Part: 647.7710

Job No: 208873

Serial No/Batch: S278966

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart
1270
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Date:

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125	QC 8	16 pcs	6/5/20	0.00	0.00	QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 2 - 76	
						QC 2 - 86	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	20/5/22 DAS 23
						QC 8 - 57	9-89
						QC 8 - 76	
						QC 8 - 61	
						QC 8 - 66	
130	Packaging 3-1 - Stock - B4B	16 pcs	6/5/20	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	DAS 28
						Packaging 3 - 7 - B4B	9-89
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	

				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140	QC 21 - SA	16 pcs	6/5/20	0.00	0.00
				QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-00
Part Op 110 - (Manufacture as per dwg) 1- CUT AS PER DWG 2- Mill end of tube as per dwg 3- DEBURR AS PER DWG Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB) 125 - (QC8- Inspect parts - second check) 130 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV*** 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M4130NT0.500W.083	4130 Round Tube .500 X .083W	13.1200 ft (.82 ea)	110-Conventional Mill - 1	527 3243	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Conventional Mill - 1	M4130NT0.500W.083	13	5	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Tube	9.750inches ± 0.005	9.755 9.745		
2	Strut Tube	0.500inches ± 0.005	0.505 0.495	Diameter	
3	Strut Tube	0.334inches ± 0.005	0.339 0.329	Diameter	
4	Strut Tube	0.188inches ± 0.005	0.193 0.183	Radius	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS			Route update only ☐				
Date: _____		Sequence #: _____			QTY Affected: _____			MRB (QS1042)				
Description Work Order Deviation		Disposition						Completed By				
								Lead hand / Supervisor				
								QC / QA Coordinator				
Root Cause		FAULT CATEGORY										
Operator		Pressure/Forced			Contamination			Power Loss/Surge			Positioned Wrong	
Manufacturing Process		Bending			Misaligned/off center			Folio/Program			Outside Tolerance	
Equip/Tooling		Crushing			BOM/Route			Grain Direction			Drawing	
Handling/Preservation		Cracks			Broken/Damage/Defect			Weld			Finish	
Material		Crimp/Kink/Ripple/Wave/Twist			Incomplete/Unclear Instructions			Wrong Stock Pulled			Part Lost/Missing	
Product Improvement		Marks/Chatter			Drill Holes			Out of Sequence			Misread	
Process Improvement		Mislabeled			Fit/Function			Off-set/Set-up				
Human Factors		Other/Details:										